

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019477**Date Inspected:** 23-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC)**Location:** Shanghai, China**CWI Name:** Li Yang and Zhu Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) at Trial Assembly Areas

Segment 12BW to Segment 12CW (Bottom Panel, Transverse Splice weld)

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as OBW12B-001. The welder identification was 040611, observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1. The piece mark was identified as the Bottom Panel, at transverse splice at work point W4.

Please reference the pictures attached for more comprehensive details.

Segment 12BW to Segment 12CW (Side Panel, Transverse Splice weld)

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as OBW12D-002. The welder

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identification was 040611, observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1. The piece mark was identified as the Bottom Panel, at transverse splice at work point W4.

Segment 12BW to Segment 12CW (Bottom Panel, Transverse Splice weld)

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as OBW12B-001. The welder identification was 057333, observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1. The piece mark was identified as the Bottom Panel, at transverse splice at work point W3.

Segment 12BW to Segment 12CW (Side Panel, Transverse Splice weld)

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as OBW12D-001. The welder identification was 057333, observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1. The piece mark was identified as the Bottom Panel, at transverse splice at work point W3.

Segment 12BW to Segment 12CW (T- Rib Splice weld)

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as SP3051-001-042. The welder identification was 046709 observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1. The piece mark was identified as the Side Panel Corner Assembly, T-Rib splice, Counter Weight side.

Segment 12BW to Segment 12CW (T- Rib Splice weld)

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as SP3041-001-040. The welder identification was 046709 observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-B-P-2213-B-U2-FCM-1. The piece mark was identified as the Side Panel Corner Assembly, T-Rib splice, Counter Weight side.

Segment 12BW (I- Rib hold back)

This QA Inspector observed the in-process welding by Flux Cored Arc Welding (FCAW) process on a Fillet weld. The Weld joint was designated as SP3053-001-021/022. The welder identification was 053486 observed welding in the 2F (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2132-ESAB. The piece mark was identified as the Side Panel Corner Assembly, I-Rib splice, Counter Weight side.

Please reference the pictures attached for more comprehensive details.

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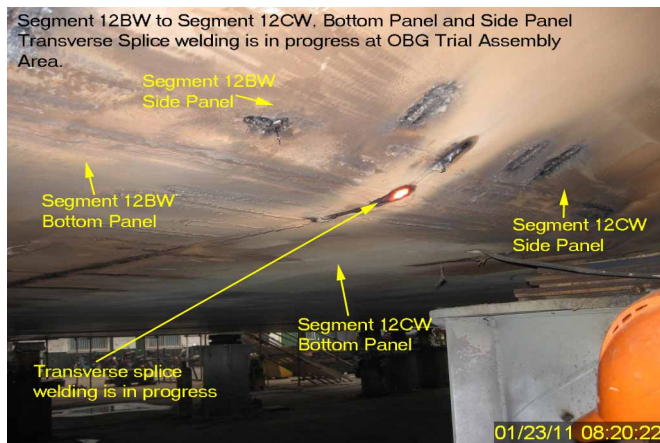
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Segment 12CW (I- Rib hold back)

This QA Inspector observed the in-process welding by Flux Cored Arc Welding (FCAW) process on a Fillet weld. The Weld joint was designated as SP3057-001-022/023. The welder identification was 053486 observed welding in the 2F (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2132-ESAB. The piece mark was identified as the Side Panel Corner Assembly, I-Rib splice, Counter Weight side.

Please reference the pictures attached for more comprehensive details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150000422372, who represents the Office of Structural Materials for your project.

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Inspected By: Math,Manjunath

Quality Assurance Inspector

Reviewed By: Dsouza,Christopher

QA Reviewer